# Proper Disc Mounting Procedure

For Roland DWX-51D / DWX-52D / 52DC / 52DCi

## Please follow the following protocols for proper mounting of discs.

- ✓ Zirconia discs must be treated with care when mounting into milling clamp.
- ✓ Incorrect disc mounting procedures can result in negative effects on your zirconia.
- ✓ Below are the proper disc mounting procedures for:
  - Roland DWX-51D
  - Roland DWX-52D
  - Roland DWX-52DC
  - Roland DWX-52DCi
- ✓ Failure to observe these protocols may lead to:
  - Marginal chipping
  - Step chipping
  - Cracking
  - Shearing
  - Broken tools
- ✓ It is imperative that **all** disc/milling debris be removed from disc clamp.
- ✓ All aspects of the mill need to be thoroughly cleaned every day – **preventative maintenance is key to long-term success.**

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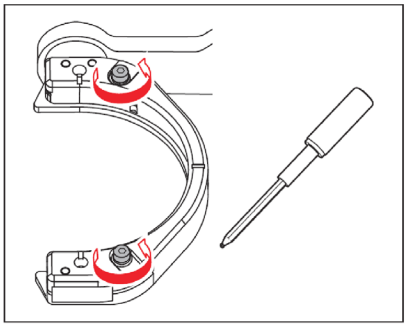
MKT-18308-ver1-12/19

# Roland DWX-51D

## Step 1

Open the clamp by loosening the screws using the provided torque wrench.

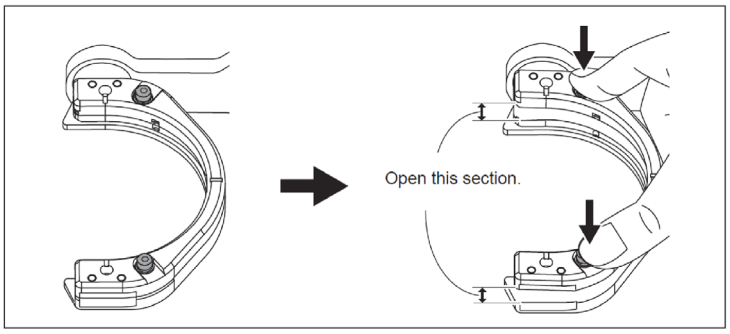


**Loosen the screws about 3 turns using a torque driver. (2 locations)**

Use the included spare screws when a screw is lost or worn.

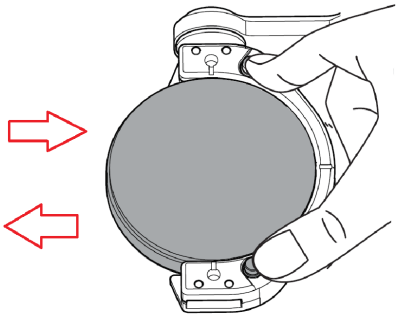
## Step 2

Push the screws down with 2 fingers to open the C clamp.



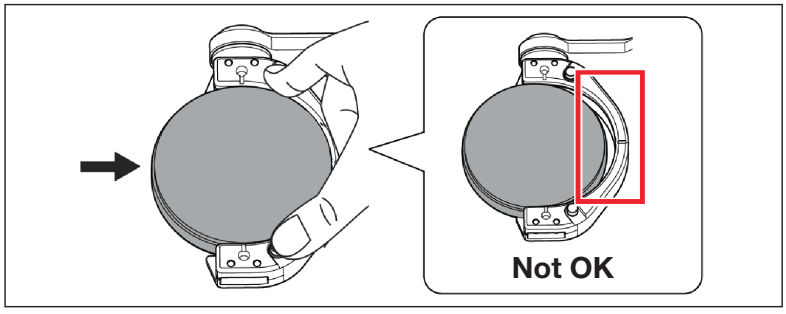

## Step 3

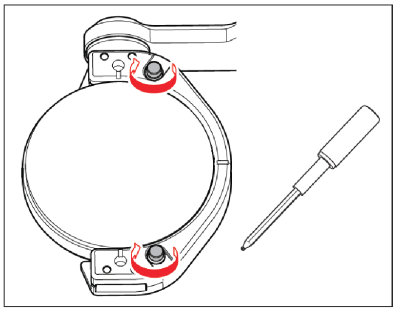
Insert disc – **do not force disc into clamp** – open the clamp more than the height of the disc to avoid and “wedging.”



## Step 4

Tighten the clamp using the provided torque driver turning ½ turn on each screw until it reaches correct torque value.



**Use a torque screwdriver to alternately tighten the screws in the two locations a half turn at a time.**

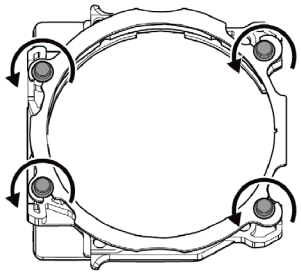
**Notice**

Tightening only one of the screws at a time may cause the workpiece to break or the screws to become loose during milling.

# Roland DWX-52D / 52DC / 52DCi

## Step 1

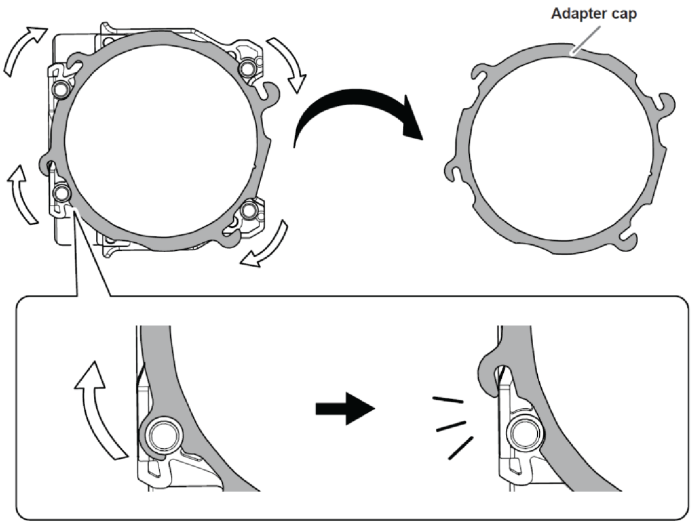
Open the clamp by loosening the screws using the provided torque wrench, turning the screws approximately 4 times.



Use the included spare screws when a screw is lost or worn.

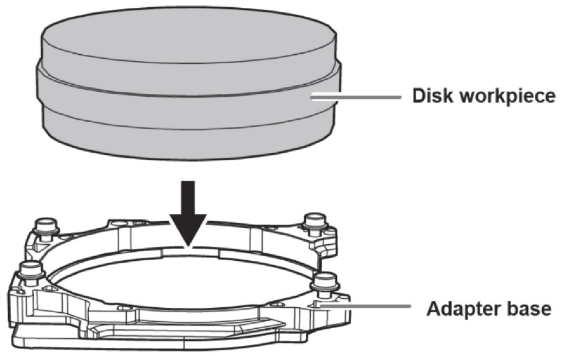
## Step 2

Remove the adapter cap.



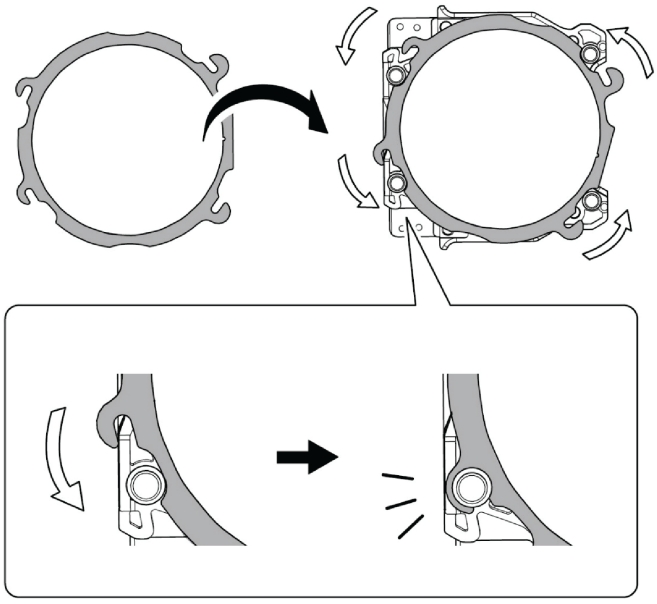

## Step 3

Mount the disc into the adapter.




## Step 4

Attach the top adapter cap to the adapter.



## Step 5

Tighten the clamp using the provided torque driver turning ½ turn on each screw until it reaches correct torque value. To prevent workpiece damage, tighten the screws in order across the diagonals.